

98117

Date: Tuesday, 27/01/2009 10:34:45 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 44095	Part Number	: D3484041
Estimate Number	: 12364	Drawing Number	: D3484 REV E
P.O. Number	:	Project Number	: N/A
This Issue	: 27/01/2009 S.O. No. :	Drawing Revision	: E
Prsht Rev.	: NC	Material	:
First Issue	: 15/12/2008 Type : LARGE FAB ASSY	Due Date	: 22/12/2008
Previous Run	: 43276	Qty:	Um: Each
Written By	:		
Checked & Approved By	:		
Comment	Est Rev:A New Issue 06-04-11 JLM Est Rev:B 08-01-24 change rivet to CR1122-3-025 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34841	Base, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 BASE, LH
 Batch: B44170

SP 09-01-29

2.0	D34843	Face, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 FACE, LH
 Batch: B4B251

SP 09-01-29

3.0	D34845	Cone, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 CONE, LH
 Batch: B36402

SP 09-01-29

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig
 A/R AL ROD Batch: M104855

(1x)

2-Buff & Smooth Welds to mating surfaces

SP 09-01-29

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Part Number: D3484041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-29 ①

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02 (H) (PTC)

See
last
page
attached

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FD 09/02/02 ①

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

WUF 09-02-02

9.0 CR1122 3 025 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)
Rivet
Batch: 106870

FF 09/02/02 ①

10.0 MS2106904 ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
ANCHOR NUT
Batch: 103693

FF 09/02/02 ①

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Install Nut Plates as per Dwg D3484

FF 09/02/02 ①

12.0 QC5 INSPECT WORK TO CURRENT STEP




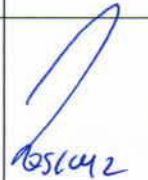



Comment: INSPECT WORK TO CURRENT STEP

S 02/02/02 (H) (LH)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3484-041 PAR #: N/A Fault Category: Prod / Fab. Large NCR: Yes No DQA: D Date: 09/02/03
 Resolution: rework Disposition: rework QA: N/C Closed: D Date: 09/02/03

NCR: <u>44095</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-30	6.0	Upon inspection a 1/2" crack was found on the final welded section. Part was ground too much. R.C: Human error. Lack of attention	 09/02/02	- More weld : less grinding on the overall part will be acceptable. - Re-weld affected area.	 09/02/02	 09/02/02	 09/02/02	 09-01-30

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 10:34:45 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44095

Part Number: D3484041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	POWDER COATING	POWDER COATING
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m109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(1)

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FL 09/02/03

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-02-03

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-141 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

FL 09/02/03

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FL 09/02/03

17.0	QC21	FINAL INSPECTION/W/O RELEASE
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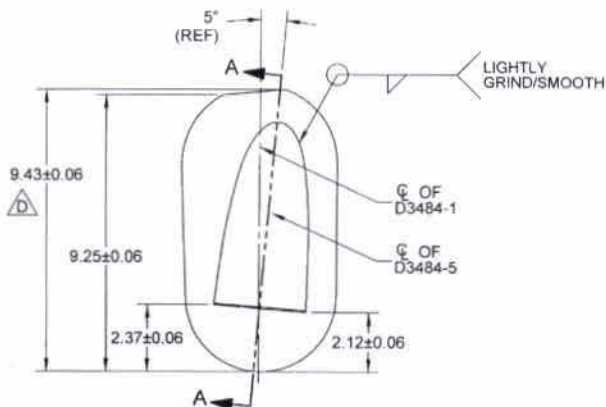
Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

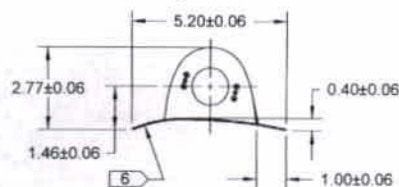
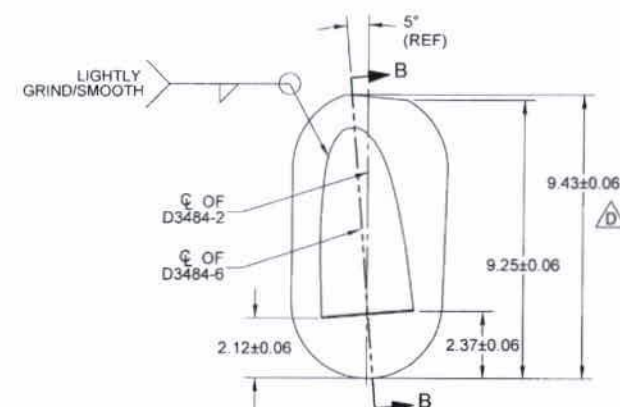
Job Completion



mf 09-02-03



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

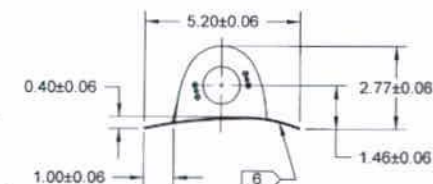


SECTION A-A

INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

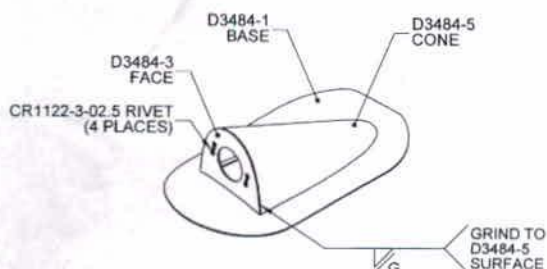


SECTION B-B

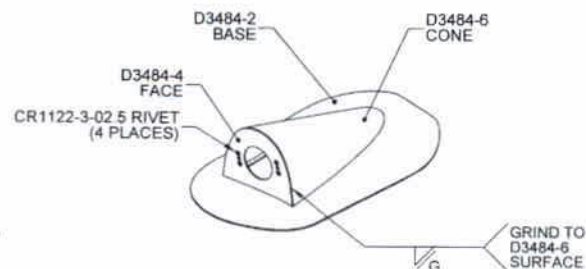


D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

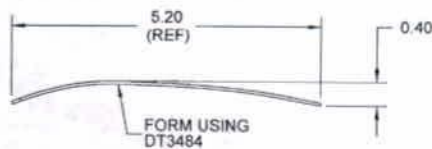
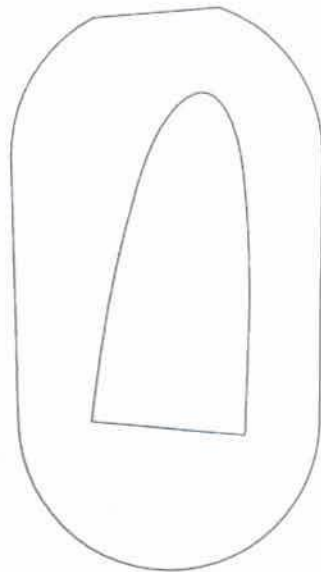
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL.
- 7) WEIGHT: 0.30 lbs

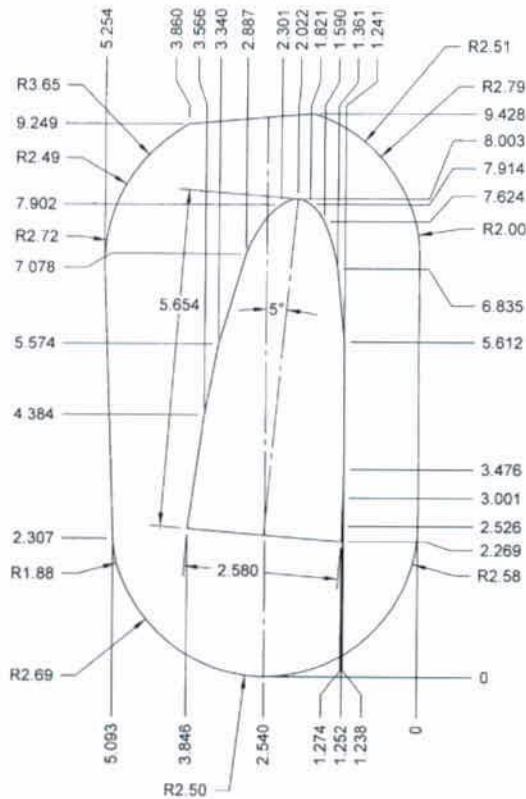
E		REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS: DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4). CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET)	MB	08.01.03
D		CORRECT D3484-1F	MB	06.06.22
C		RE-DESIGN D3484-3F/5F	MB	06.04.20
B		RE-DESIGN	MB	06.02.21
A		NEW ISSUE	MB	05.11.29
REV	DESCRIPTION		BY	DATE
DESIGN	LH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3484 TITLE TAIL LIGHT FAIRING SCALE 1:4 COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	
DRAWN	LH			
CHECKED	ME			
MFG. APPR.	ME			
APPROVED	ME			
DE APPR.	ME			
DATE	08.01.03			
		DRAWING NO.	REV. I	
		TITLE	SHEET 1 OF	
		TAIL LIGHT FAIRING	SCALE	1:4

RELEASED
06-01-11

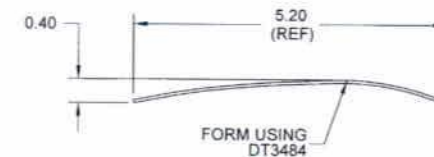
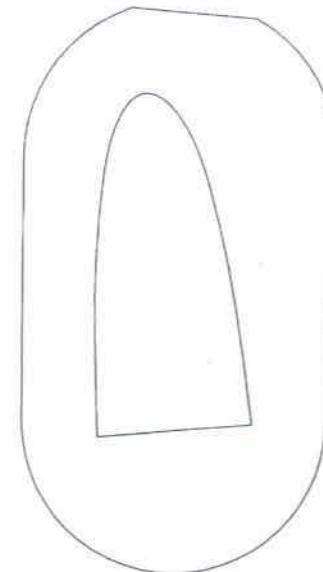
100409



D3484-1 BASE
(MAKE FROM D3484-1F)



D3484-1F BASE FLAT PATTERN



D3484-2 BASE
(MAKE FROM D3484-1F)

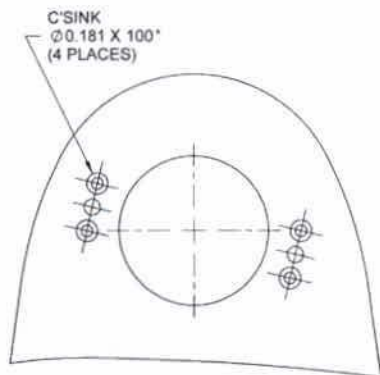
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S 050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

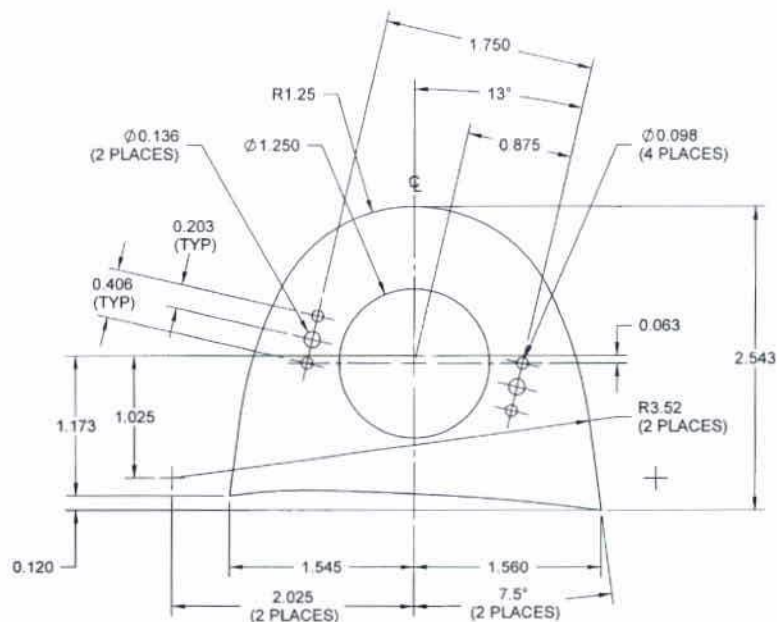
44095

RELEASED
02-01-17

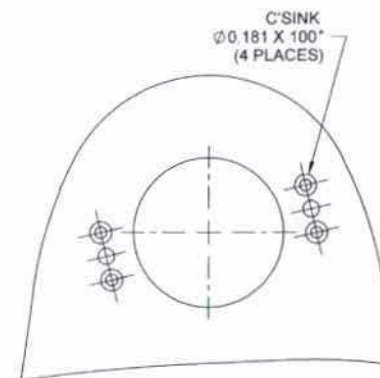
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CHECKED		DRAWING NO. D3484	REV. E
MFG. APPR.		TITLE	SHEET 2 OF 4
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DE APPR.			1:2
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D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING



D3484-4 FACE
(MAKE FROM D3484-3F)

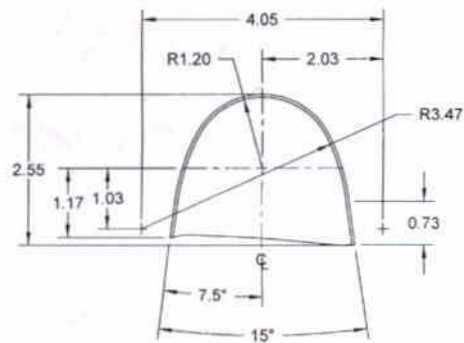
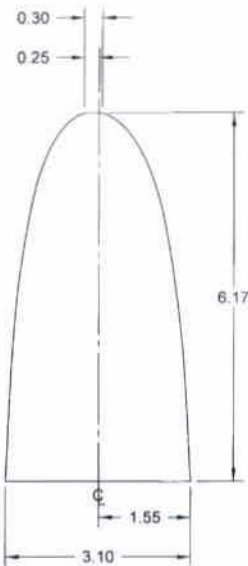
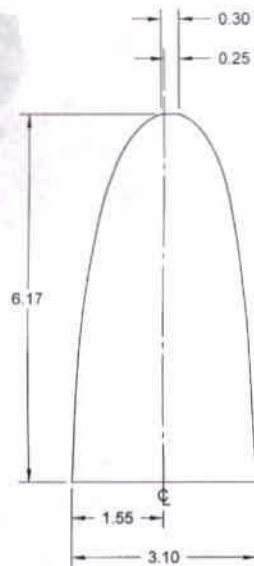
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

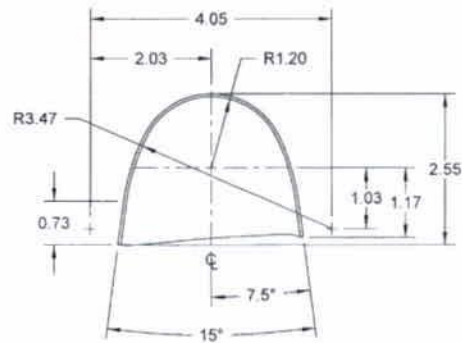
440 95

08.01.17 MD

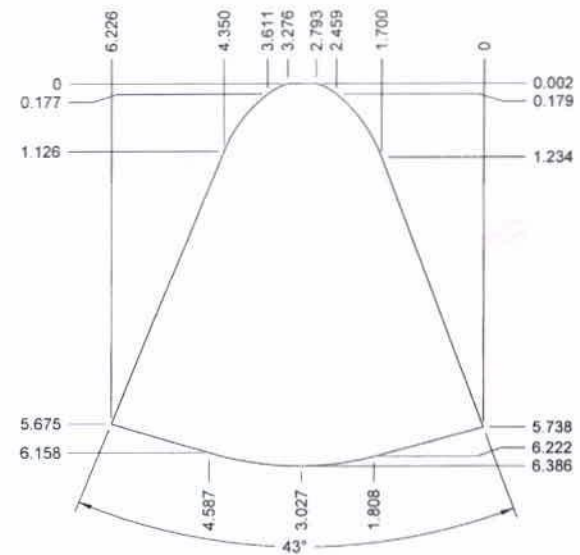
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. E
MFG. APPR		D3484	SHEET 3 OF 4
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DE APPR		TAIL LIGHT FAIRING	1:1
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D3484-5 CONE
(MAKE FROM D3484-5F)



D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG APPR		D3484	SHEET 4 OF 4
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DE APPR.		TAIL LIGHT FAIRING	1:2
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44095